

Work Order ID 55310 - 2

January 13, 2010 10:19:28 AM

Page 1

Item ID: D2230-3

Revision ID:

Item Name: Lug

Start Date: 1/13/10

Required Date: 1/20/10

Reference:

Approvals:

Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2230

Rev F

100



Bandsaw

Jeaspa Bandsaw

BAND SAW

Memo

Cut D2423 extrusion to 0.82"
Batch:

0.00

0.00

Cut At Metec U

110



HAAS I

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

1-Machine per folio D2230-3
Check for crack while loading into the machine.
2- deburr

0.00

0.00

Issue to.
PO11124

RG- Receive & Inspect

120



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

RG 10-1-14
(200)
~~Part 10-1-14~~
10/2/1 (100)

Work Order ID 55310

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Page 2

Item ID: D2230-3

Revision ID:

Item Name: Lug

Start Date: 1/13/10

Required Date: 1/20/10

Reference:

Accept



Setup Start



Stop



Start Qty: 200.00

Req'd Qty: 200.00



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

Solver 16

10/02/10
+150
ASPOL

150



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

BR 10-02-17

150

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

10/02/17

150

Work Order ID 55310

January 13, 2010 10:19:28 AM

Page 3

Item ID: D2230-3

Accept

Revision ID:

Item Name: Lug

Start Date: 1/13/10

Start Qty: 200.00

Required Date: 1/20/10

Req'd Qty: 200.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

170



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

M113170

7/11 10:02-18

(X150) Ø

Memo

0.00

START TIME: 7:00AM
OVEN TEMPERATURE: 320°F
FINISH TIME: 7:30AM

180



QC

Quality Control

QC3-Inspect Part Finish

0.00

10/02-18

(150)

Memo

0.00

190



Packaging

Packaging

Identify as per dwg & Stock Location:

0.00

Memo

0.00

10/02/22 (150)

Work Order ID 55310

January 13, 2010 10:19:28 AM



Page 4

Item ID: D2230-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Lug

Start Date: 1/13/10

Start Qty: 200.00



Cust Item ID:

Required Date: 1/20/10

Req'd Qty: 200.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/02/23 *[Signature]*

MF
10-2-22

Picklist Print

January 13, 2010 10:19:31 AM

Page 1

Work Order ID: 55310



Parent Item: D2230-3



Parent Item Name: Lug

Start Date: 1/13/10

Required Date: 1/20/10

Comments: IPP D: 00.05.18 Added inspection level 8, and removed P/O for powder coat EC

Start Qty: 200.00

Required Qty: 200.00

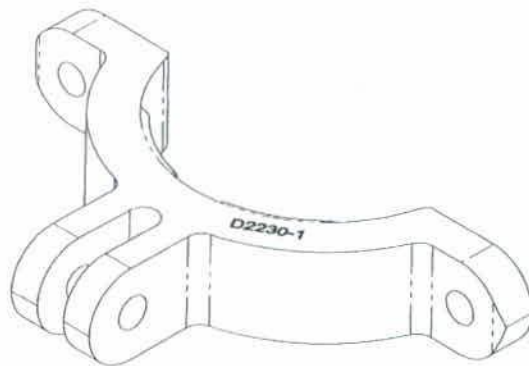
| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| D2423 | | Manufactured | No | | | 100 | f | 604.4578 | 14.3789 | | | |



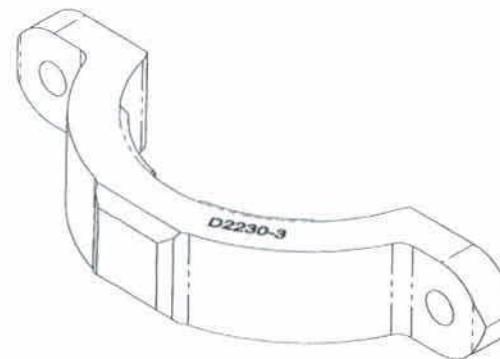
Lug Extrusion

| Warehouse Location | Loc Qty | Loc Code |
|-----------------------|-------------|----------|
| Main Warehouse | | |
| ST | 604.4578379 | |
| 43722 | 175.629406 | |
| 44529 | 5.7731 | |
| 45800 | 423.055332 | |

MF 10-2-22



D2230-1 MOUNTING LUG



D2230-3 MOUNTING LUG

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 55310
B/C-1-13

RELEASED
09/01/16

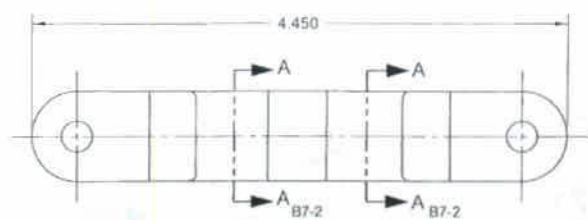


NOTES:

- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ± 0.005 IN THIS LOCATION, WITH TOOL TIP RADIUS OF 0.015 ± 0.005
- 7) WEIGHT: -1: 0.16 lbs
-3: 0.14 lbs

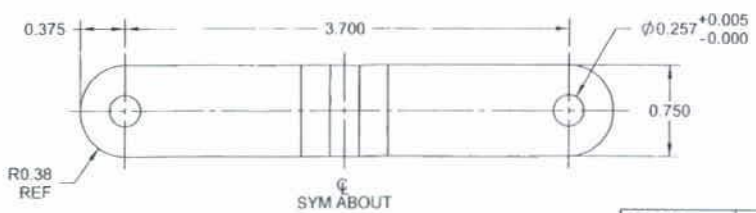
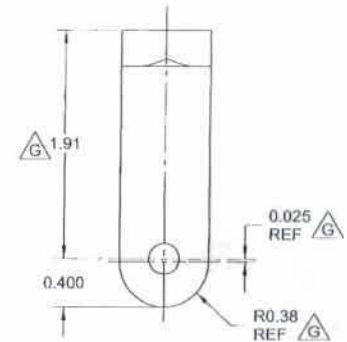
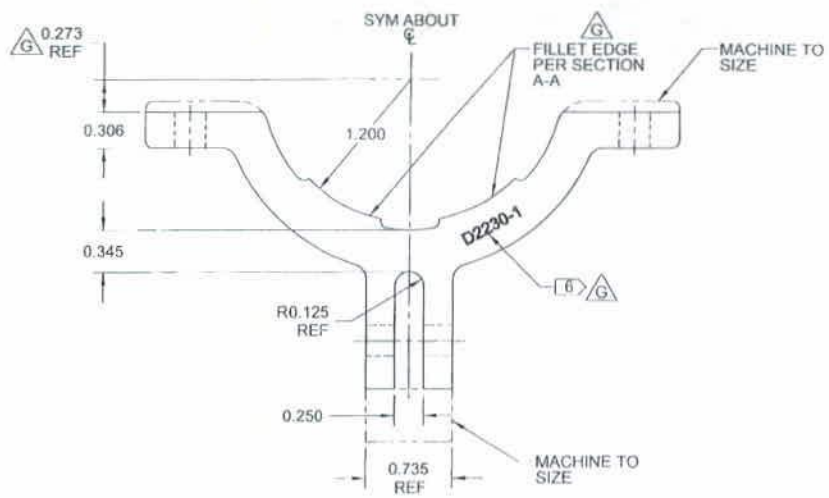
| G | REDRAWN IN SOLIDWORKS TO CURRENT DESIGN STANDARDS. REFER TO SECTION A-A & B-B FILLET ADDED TO PREVENT CHAFING OF RUBBER CUSHION ON INSTALLATION. | AJS | 09.01.16 |
|------------|--|--|----------|
| F | REDESIGN; R1.200 WAS 1.100 | CP | 99.12.13 |
| E | RE-DESIGN | BW | 95.01.04 |
| D | RE-DESIGN | BW | 95.01.04 |
| C | RE-DESIGN | BW | 94.03.30 |
| REV | DESCRIPTION | BY | DATE |
| DESIGN | BW | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D2230 TITLE MOUNTING LUG COPYRIGHT © 1984 BY DART AEROSPACE LTD THIS DOCUMENT IS THE PROPERTY OF DART AEROSPACE LTD. IT IS TO BE USED FOR THE PURPOSES FOR WHICH IT WAS ISSUED AND NOT BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM. | |
| DRAWN | AJS | | |
| CHECKED | | | |
| MFG. APPR. | | | |
| APPROVED | | | |
| DE APPR. | | REV. G SHEET 1 OF 3 SCALE NTS | |
| DATE | 09.01.16 | | |

8 7 6 5 4 3 2 1



SECTION A-A D4.2
SCALE 2X

R0.06 MIN - R0.10 MAX
2 PL



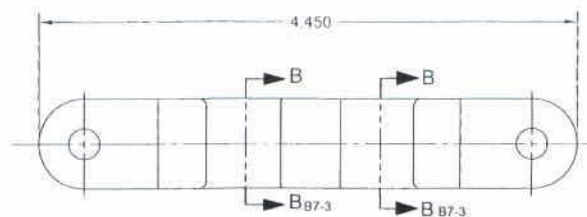
D2230-1 MOUNTING LUG

RELEASED
09/06/75

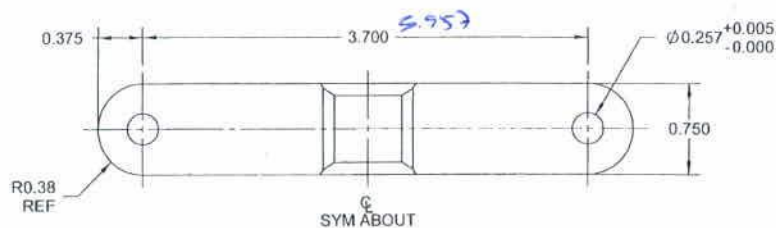
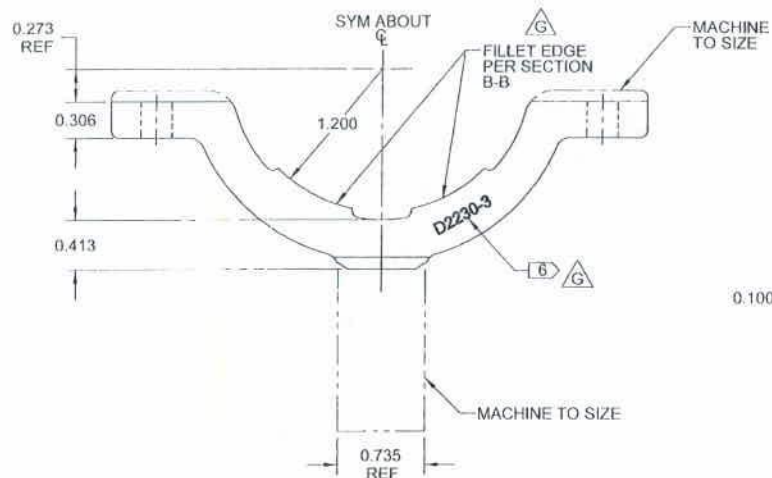
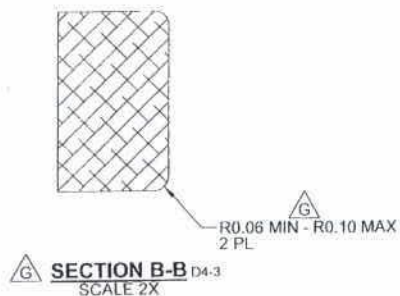
W10 55310

| | | | |
|------------|----------|---|--------------|
| DESIGN | BW | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | AJS | | |
| CHECKED | | DRAWING NO. | REV. G |
| MFG. APPR. | | D2230 | SHEET 2 OF 3 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | MOUNTING LUG | NTS |
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8 7 6 5 4 3 2 1



60
120
150



D2230-3 MOUNTING LUG

RELEASED
07/06/23

| | | | |
|------------|----------|---|--------------|
| DESIGN | BW | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | AJS | | |
| CHECKED | | DRAWING NO. | REV. G |
| MFG. APPR. | | D2230 | SHEET 3 OF 3 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | MOUNTING LUG | NTS |
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W/O 55310



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO11126

Purchase Order Date 1/14/10

PO Print Date 1/14/10

Page Number 1 of 1

Order From :

VC-MET003

METEC METAL TECHNOLOGY INC.
20 TERRY FOX DRIVE PO BOX 781
VANKLEEK HILL, QC K0B 1R0
CA



| | | | |
|--------------------|--------------|-----------------|----------------|
| Contact Name | | Buyer | Chantal Lavoie |
| Vendor Phone | 613 678 3957 | Requisition Nbr | |
| Vendor Fax | 613 678 3956 | Tax Resale Nbr | 10127-2607 |
| Vendor Account Nbr | | Terms | Net 30 |
| | | Currency | CAD |
| | | FOB | |

Ship To : DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

| Line Nbr | Reference Revision ID Vendor Part Number | Description/ Mfg ID | Req Date/ Taxable | Req Qty/ Unit of Measure | Ship Method | Unit Price |
|----------|--|------------------------|---|-----------------------------|-------------|------------|
| 1 | D2230-3P | LUG | 1/18/10 Yes | 200.00 Each | Yours ppd | \$10.4000 |
| | | Special Inst: | MACHINE AS PER DWG D2230 REV.F MAT. SUPPLY BY DART D2423 B45800 | | | |
| 2 | D3235-1P | lug | 1/18/10 Yes | 60.00 Each | Yours ppd | \$13.9000 |
| | | Special Inst: | MACHINE AS PER DWG: D3235 REV. A MATERIAL SUPPLY BY DART D2423 B45800 | | | |

REC'd 5-1/14/10
MIL 100/1/11

PO Total:

Change Nbr: 1

Change Date: 1/14/10

No substitution or deviation with
consent.
Certificate of Conformity or Material
Certification required when applicable



20 Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0
Tel: (613) 678-3957
Fax: (613) 678-3956

Delivery Slip No.: 17221

Date: Feb 11, 2010

Page: 1

| | |
|---|--|
| Sold to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7 | Ship to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7 |
| Order No.: 11126 | Sold By: Walz, Christian D. |
| Shipped By: our truck | Ship Date: |

| Description | Unit | Ordered quantity | Shipped quantity | Backorder quantity |
|--|------|---------------------------|------------------|--------------------|
| D2230-3 Mounting Lug Material supplied by DART D2423 B45800 | Each | 200 | 150 | |
| D3235-1 Mounting Lug Material supplied by DART D2423 B45800 | Each | 60 | | 60 |
| Received by _____ | | Thank you for your order! | | |

CERTIFICATE OF CONFORMITY

SOLD TO

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

QUANTITY

PART NUMBER

PART NAME

P.O. NUMBER

150

D2230-3

Mounting Lug

11126

MATERIAL: supplied by DART D2423 B45800

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.


Shigi Walz


20/02/10

Vankleek Hill, February 11, 2010